

Date: Thursday, 8/30/2007 3:51:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT	
Job Number	: 34363				
Estimate Number	: 10284				
P.O. Number	: N/A		Part Number	: D2565109	
This Issue	: 8/30/2007 S.O. No. : N/A		Drawing Number	: D2565 REV E	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: E	
Previous Run	: 33051		Material	: N/A	
Written By			Due Date	: 9/12/2007	
Checked & Approved By			Qty:	13	
Comment	: Est:F 02.04.16 Added dwg Rev.C1 NG		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		Comment: Qty.: 1.0771 f(s)/Unit Total : 10.7709 f(s) <i>14.0023</i> Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall <i>(M304TR0750W049)</i> Batch No: <i>M105354</i> FF <i>07-09-13</i>
2.0	BRAKE NC	NC BRAKE
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 FF <i>07-09-13</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <i>SAD 07/09/13</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP <i>En 07/09/14 x 13</i>
5.0	POWDER COATING	POWDER COATING
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 <i>Mjt 07/09/18</i>
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		Comment: INSPECT POWDER COAT <i>En 07/09/18</i>

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr
						Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 07/09/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/17	# 5.0	I part was found with the mat. numbers showing through the powder coat.	J 031042	Remove Powder coat and Bull out numbers wash with wash wine # inspect QC #5	J 07/09/17 22 En. Shaloo	En. Shaloo	J 031042	En. Shaloo
		J	J	Re powder coat as per QSI 005	M. H 07/09/18 07/09/18	En. Shaloo	J	J

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 259

gj 07/09/18 (13)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/19

Job Completion



07/09/19

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

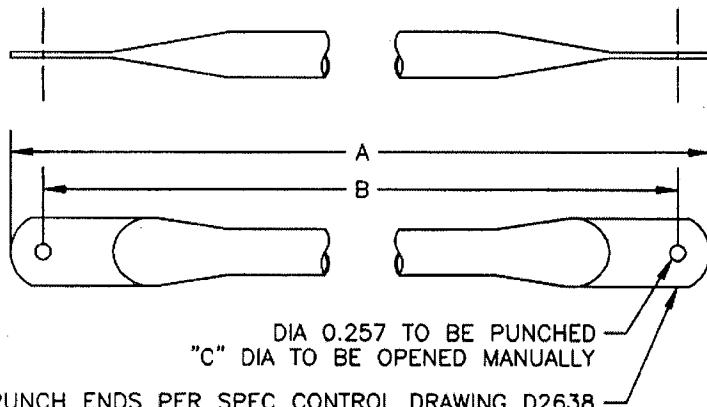
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
		D2565		SHEET 1 OF 1
DATE		TITLE	SCALE	
04.05.05		STRUT	1:3	
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

RELEASED
04.05.05

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF. DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34363

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